

Work Order ID 80585

80585

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February-23-12 1:23:55 PM

Item ID: D412-664-203

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Crosstube Aft

Stop *NS2*

Start Date: 23/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/02/23 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-664-243	E/DEO								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels as per PPP D412-664-203 CHG 008								
110	Packaging	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	BENDING MACHINE - CROSSTUBES	0.00							
120									
CNC Bend 2	Memo	0.00							
CNC Alpha 160 Bender	Bend tube as per Dwg D412-664-243 using CNC bender program 412-aft and Folio FT010								

D412-664-203/80585

ml 12-03-23 B
HJ for MLJ 12-3-22

12-3-5

Pto

12-3-5

TW
Rm

W/O: 80585		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-664-203 PAR #: _____ Fault Category: X-tube NCR: Yes No DQA: ✓ Date: 12/03/28
 Resolution: use on is Disposition: use on is QA: N/C Closed: ✓ Date: 12/3/28

NCR: 12-1291		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.03.05	120	CRUSHING AFTER BENDING IS OVER TOLERANCE AT BOTTOM OF BEND	<u>CP</u> 12.03.05 CP5/042	Acceptable per attached SR	<u>u/4</u>	<u>8</u> 7/13/05	<u>CP</u> 12.02.05 CP5/042	<u>S</u> 7/13/05

NOTE: Date & initial all entries

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1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00

130

QC

Memo

0.00

5/26/15

Quality Control

140

Crosstubes

0.00

140

Crosstubes

Memo

0.00

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 and drill table DT8577 using #9 holes as per QSI 10 to install towers.

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-SCRIBE PART # & BATCH #

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

MO

12/3/5

MO

12/3/6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 80585***80585***

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Aft

Start Date: 23/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFXtube Hand Finishing Crosstubes	Crosstubes Chemical Conversion Memo	0.00 0.00		MO		12	13/6		
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		8/2/03/07					
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/2/03/07		10			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80585

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 23/02/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 14/03/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180	Outsource process - NDT per QSI038 4.1	0.00
-----	--	------

180

Outsource2

Outsource process - NDT

Memo

0.00

Liquid Penetrant Inspection as per QSI 038Or
Issue P/O: 14399 LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order

190 0.00

190

Packaging

Packaging

Packaging

Memo

0.00

Inspect for transit damage
Ensure copy of NDT results attached to work order.

200	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

200

QC

Quality Control

Memo

0.00

Inspect for damage & ensure results are as per Dwg D412-664-203

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 80585***80585***

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Start Date: 23/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	SprayPaint	0.00							
210									
SprayPaint	Memo	0.00							
Spray Painting	***Mask underside of crosstube as shown***								
	1-Prime inside and outside crosstube as per QSI 005 4.2								
	2-Paint outside crosstube with White Imron as per DEO D412-664-243 and QSI 005 4.2								
	PRIME:								
	Start Time: 9:45								
	Finish Time: 10:30								
	PAINT:								
	Start Time: 1:15								
	Finish Time: 2:30								
220	QC14- Inspect Spray Paint	0.00							
220									
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								

AS 12-3-15

12-03-19 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Aft

Stop ***NS2***

Start Date: 23/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Crosstubes	0.00							
230									
Crosstubes	Memo	0.00							
Crosstubes	Assemble as per Dwg D412-664-203								
	1- Install chafing shield as per DEO D412-664-243. Top holes should be facing up. A/R Proseal 890 Batch: <u>120867</u> EXP: <u>11/12</u>								
	2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe								
	3- Install support with Scotch-Weld DP460 and install clamps as per DEO Dwg D12-664-243 using installation jig DT9024. Torque clamps as per dwg A/R Scotch-Weld DP460 Batch: <u>120389</u> EXP: <u>14 Mar. 2013</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									

12 - 3 - 20

12 . 03 . 22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80585

80585

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Item ID: D412-664-203

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Aft

Stop ***NS2***

Start Date: 23/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

12/3/23

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

12 - 03 - 23

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27

for application time & date *****

Time & date of packaging: REQ 1

Location: 103

12/3/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80585***80585***

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Item ID: D412-664-203

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Aft

Stop ***NS2***

Start Date: 23/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

12/3/26
12-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-23-12 1:23:59 PM

Page 1

Work Order ID: 80585

80585

Parent Item: D412-664-203

D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 23/02/2012

Required Date: 14/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:E04.02.16Reformat; Added D3189-1K/DS
 IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
 IPP Rev:G 06.12.08 per ECN 886 EC
 IPP Rev:H 07-04-30 As per Rev D JLM
 IPP Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC IPP rev J
 11.04.21 DEO D412-664-243-E-1 EC verified DD IPP REV:K
 11.10.03 DEO D412-664-243-E-2 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D412-664-203TRN

Manufactured No

B80133

110

Each

2.0000

1

**

①

JW 12-3-1

D412-664-203TRN

Crosstube Turning Detail

Location

Loc Qty

Loc Code

LG

2

80128

1

80131

1

D2896-1

Manufactured No

230

Each

22.0000

1

1

**

AL 12-3-20

D2896-1

Support

Location

Loc Qty

Loc Code

LG053

22

71502

1

74465

21

1

D3189-1

Manufactured No

230

Each

37.0000

2

2

**

AL 12-3-20

D3189-1

Chafing Shield

Location

Loc Qty

Loc Code

FG

4

36065

4

LG053

33

76473

22

79796

11

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 80585

80585

Parent Item: D412-664-203

D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 23/02/2012

Required Date: 14/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3595-063-570

Manufactured No

230

Each

114.0000

2

2

D3595-063-570

RUBBER CUSHION

**

AS 12-3-20

Location

Loc Qty

Loc Code

FG

8

37971

1

42243

7

MAT052

106

71534

29

76546

77

2

MS21920-28

Purchased

No

230

Each

39.0000

4

4

MS21920-28

Clamp(per MIL-DTL-8783C)

**

AS 12-3-20

120884

4

Location

Loc Qty

Loc Code

FG

5

105884

5

LG050

34

116839

2

118713

4

119285

1

119920

1

120054

26

MS21920-30

Purchased

No

230

Each

80.0000

2

2

MS21920-30

clamp(per MIL-DTL-8783C)

**

AS 12-3-20

Location

Loc Qty

Loc Code

LG

50

119529

50

LG050

16

117998

16

LG051

14

111258

14

2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80585

80585

Parent Item: D412-664-203

D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 23/02/2012

Required Date: 14/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN6-40A

Purchased

No

250

Each

108.0000

4

4

AN6-40A

Bolt

**

M120833

Location

Loc Qty

Loc Code

ST342

108

119749

8

120187

100

AN6-41A

Purchased

No

250

Each

87.0000

2

2

AN6-41A

Bolt

**

Location

Loc Qty

Loc Code

ST342

87

119749

20

120187

17

120423

50

AN960JD616

NAS1149D0663J

Purchased

No

250

Each

0.0000

18

18

AN960JD616

Washer

**

M119075

MS21042L6

Purchased

No

250

Each

1,072.000

6

6

MS21042L6

Nut

**

21362

Location

Loc Qty

Loc Code

ST300

1072

117677

25

118384

3

118927

48

119075

796

120308

200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

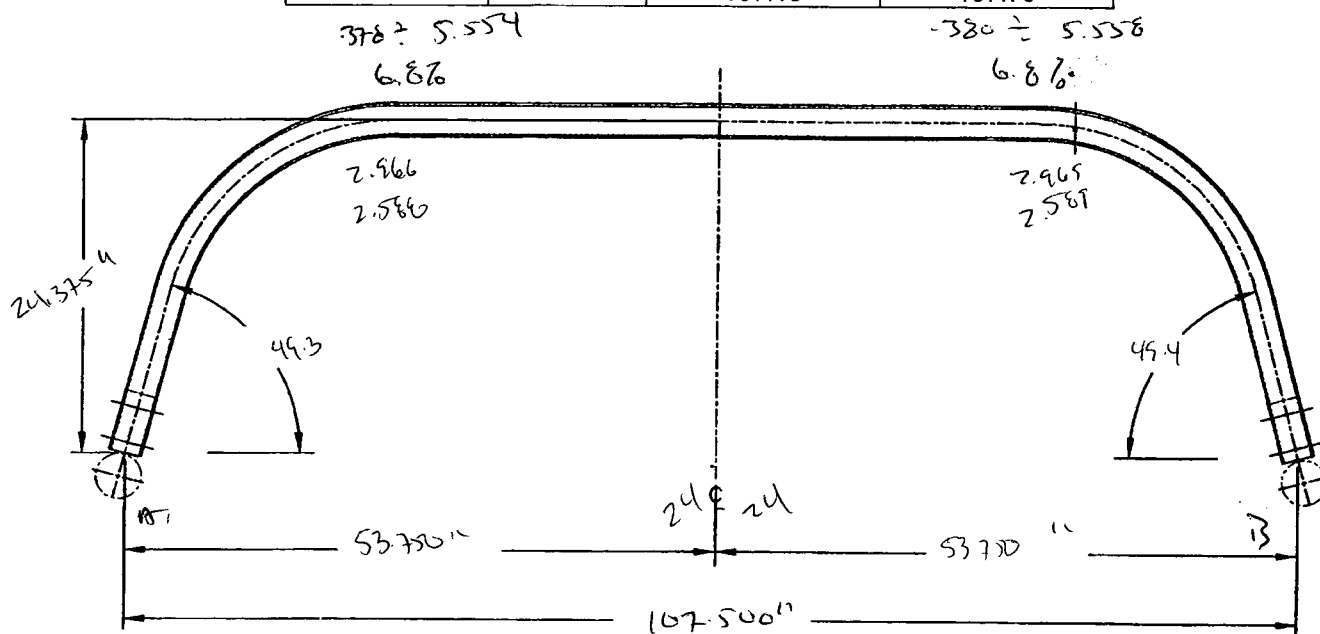
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80585
Description: Crosstube High Aft (412)		Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments
Side A = 6.8% crushing @ 24 passes
Side B = 6.8% crushing @ 24 passes

QC15 Inspection	8
Date	26/3/05

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	
C	10.02.02	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Item	Qty -243	Part Number	Description
1	X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
2	1	D6009-129	CROSSTUBE
3	2	D3595-063-570	RUBBER CUSHION
4	1	D2896-1	SUPPORT
5	2	D3189-1	CHAFING SHIELD
6	2	D2856-600-1009	ABRASION STRIP
7	4	MS21920-28	CLAMP
8	2	MS21920-30	CLAMP (OR MS21920-32)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.100±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D412-664-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 47.0 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE THE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 15) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 16) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

PHOTO COPY

80585 M.C.J
12/02/23

② DEO ATTACHED

RELEASED
2009-10-29
WVP

E	REFORMAT/REVISE GENERAL NOTES; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; RELOCATED FLAG #8 PER PAR 08-046 (ZN A6-3); ADD TOLERANCE (ZN B6-3, C4-3, C8-3 & C5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	09.09.30
D	REMOVE D2732-058, CHANGE TO D3595-063-570	PH	07.03.09
C	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398, MS21920-32 WAS MS21920-30	MB	06.10.27
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	01.10.17
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9P	DRAWING NO.	REV. E
MFG. APPR.	DS	D412-664-243	SHEET 1 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	14	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

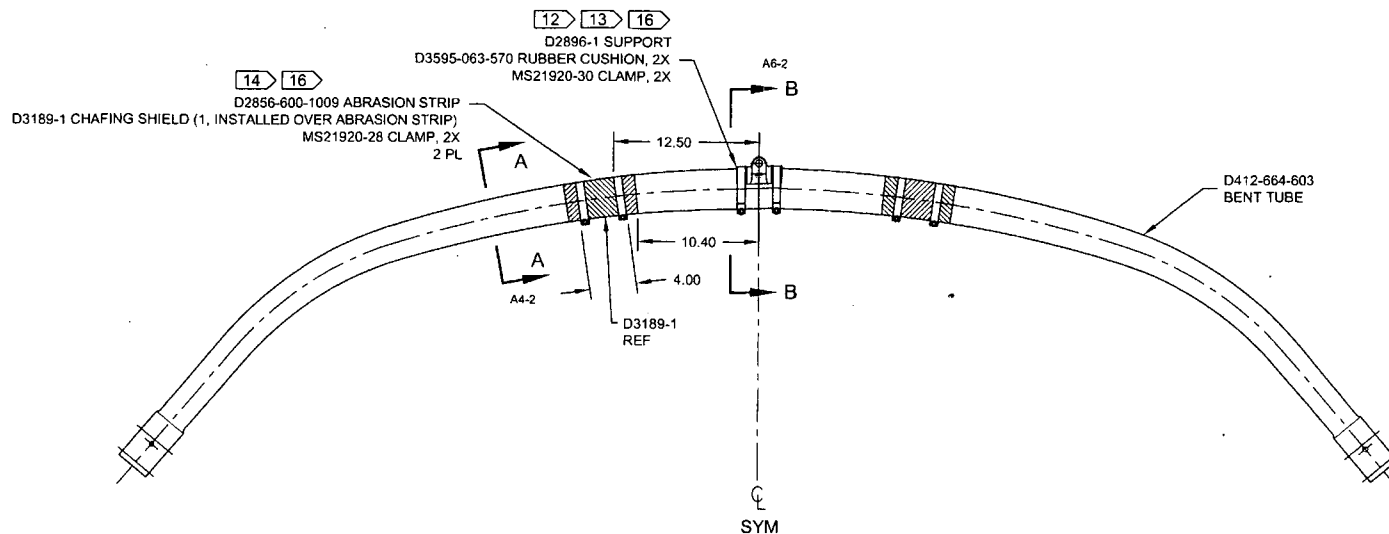
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

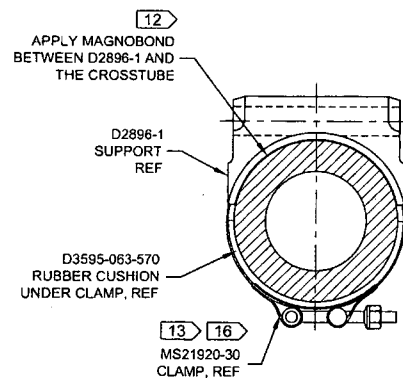
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

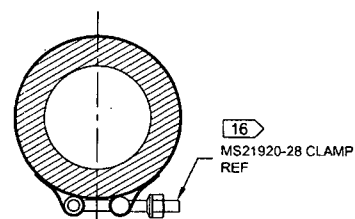
NOTE: Date & initial all entries



D212-664-243
ASSEMBLY DETAIL



SECTION B-B D4-2
SCALE 4X



SECTION A-A C6-2
SCALE 4X

2 DEO ATTACHED
RELEASED
2009-10-29
MK

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. E
MFG. APPR.	92	D412-664-243	SHEET 2 OF 4
APPROVED	92	TITLE	SCALE
DE APPR.	92	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

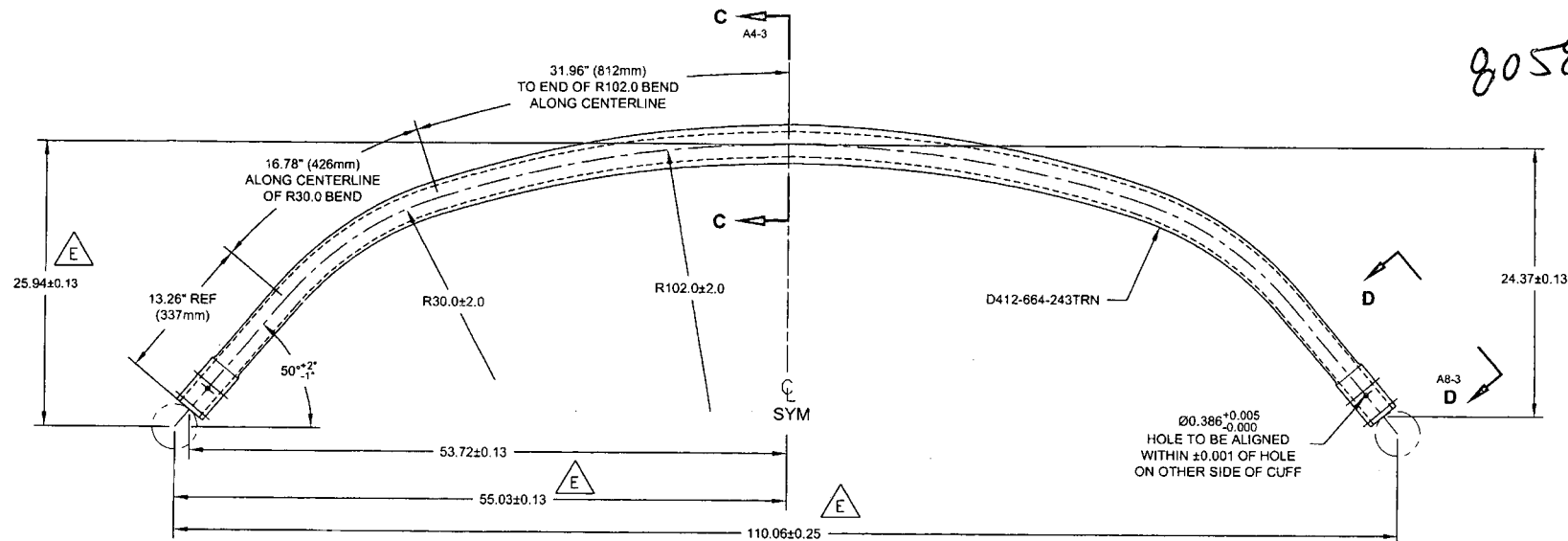
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

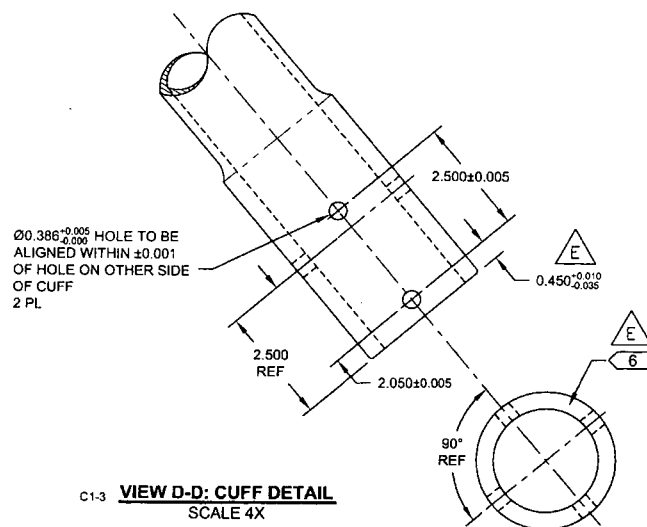
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

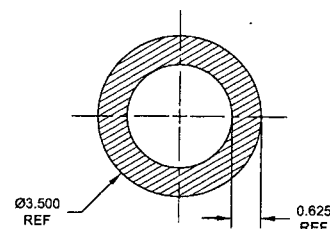
80585



D412-664-603 10 E
BENDING AND DRILLING DETAIL



VIEW D-D: CUFF DETAIL
 SCALE 4X



SECTION C-C D5-3
 SCALE 4X

2 DEO ATTACHED

RELEASED

2009-10-29

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	Q	DRAWING NO.	REV. E
MFG. APPR.	SS	D412-664-243	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	TH	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2001 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

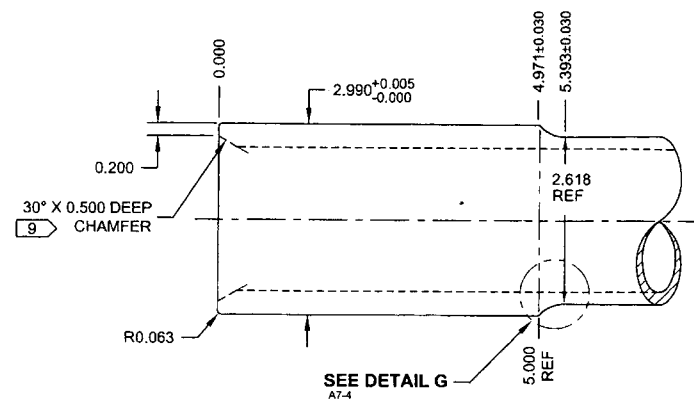
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

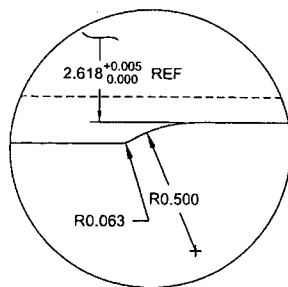
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

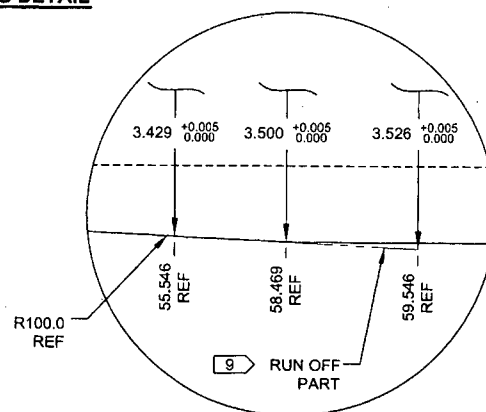
NOTE: Date & initial all entries



DETAIL E:
CROSSTUBE CUFF 08-
SCALE 5X



DETAIL G:
CUFF TRANSITION C2-4
SCALE 10X



DETAIL F:
TAPER RUN-OFF C4-
NOT TO SCALE

② DEO ATTACHED

RELEASED
2009-10-29
MD

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. 0
MFG. APPR.	DS	D412-664-243	SHEET 4 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	#	CROSSTUBE ASSEMBLY (412 HI AFT)	NT
DATE 09.09.30		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PARTY WITHOUT PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D412-664-243	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D412-664-243-E-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 11.03.31	DATE 11/03/31	DATE 11.03.31	DATE 11/03/31	DATE 11.03.31			

PURPOSE:

REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890.

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

Item	Qty -243	Part Number	Description
6	0	D2856-600-1009	ABRASION STRIP

WAS:

6	2	D2856-600-1009	ABRASION STRIP
---	---	----------------	----------------

NOTES 2 AND 14, SHEET 1 ARE AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA)
PAINT OUTSIDE PER DART QSI 005 4.2
AFTER PAINTING, APPLY CLEAR COAT ON HATCHED AREA
- 14) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3189-1
CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL
PROSEAL D3189-1 CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF
PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF
CROSSTUBE PER QSI 035.

RELEASED
2011-04-07
MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D412-664-243	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D412-664-243-E-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 11.03.31	DATE 11.03.31	DATE 11.03.31	DATE 11.03.31	DATE 11.03.31		

IS:

D3189-1 CHAFING SHIELD (1, INSTALLED OVER PROSEAL 890)
MS21920-28 CLAMP, 2X
2 PL

D412-664-603
BENT TUBE

2.00
1.00

WAS:

14 16

D2856-600-1009 ABRASION STRIP
D3189-1 CHAFING SHIELD (1, INSTALLED OVER ABRASION STRIP)
MS21920-28 CLAMP, 2X
2 PL

D3189-1
REF

**D412-664-243
ASSEMBLY DETAIL**

RELEASED
2011-04-07
MD

2

MASK AREA PRIOR TO PAINTING AND
APPLY CLEAR COAT AFTER PAINTING

2.00

C
SYM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D412-664-243	TITLE CROSSTUBE ASS'Y (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D412-664-243-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 97	CHECKED ASS	MFG. APPR. E	APPROVED MP		DE APPR. H		
DATE 11.09.07	DATE 11.09.19	DATE 11.09.19	DATE 11.09.19		DATE 11.09.19		

80585

PURPOSE:

REPLACE MAGNOBOND WITH 3M DP460 SCOTCH-WELD EPOXY ADHESIVE

CHANGE:

IS:

Item	Qty -243	Part Number	Description
9	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	----------------	---

NOTE 12 & 16, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) INSTALL D2896-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.

WAS:

- 12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-09-29
MP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

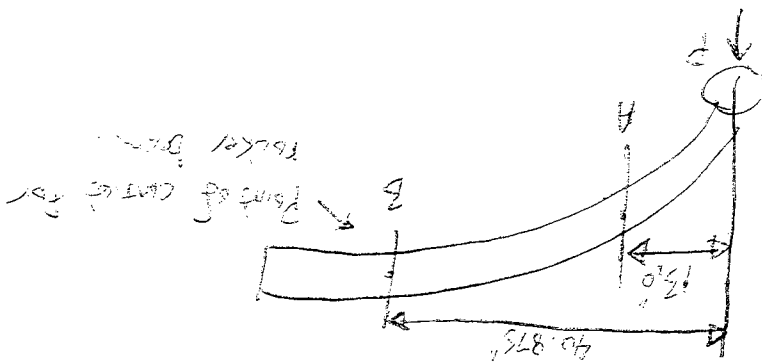
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

11.12.06

CRUSHING OF D412-669-247

Acceptability of 8% CRUSHING AT END OF BEAM



Point A: $OD_1 = 2.961$, $OD_2 = 2.522$

CRUSHING = $(2.961 - 2.522) / (2.961 + 2.522) = 8\%$
 $I = 1.676 \text{ in}^4$ (from AutoCAD)

Point B: $OD_1 = 3.307$, $I = 4.613 \text{ in}^4$

Point A: $F = M_c / I = P \times 13 \times 2.961 / 2 \times 1.676 = 11,984.5$
 $B: = P \times 40.875 \times 3.307 / 2 \times 4.613 = 14,651.7$

M.S. = $14,651 / 11,984 - 1 = 0.27$

∴ Tube will break at rocker beam contact before cross of 8% crushing in area of end of tube
 Bond is acceptable

11.12.06



ACUREN

LIQUID PENETRANT TEST REPORT

P- 05641

CLIENT

ATTENTION

ADDRESS

PROJECT

ITEM(S) EXAMINED

DATE

ACUREN JOB NO.

PO/WO NO.

WORK LOCATION

ACCEPTANCE STD.

PAGE

OF

TIME

AM

PM

JOB DESCRIPTION

PROCEDURE NO. LT-003 REV./DATE

2007

TECHNIQUE NO. LT-002 REV./DATE

2007

ART NO.

MATERIAL

THICKNESS

SCOPE

TEST DETAILS

METHOD

☒ FLUORESCENT☐ VISIBLE☒ WATER WASH☐ SOLVENT REMOVABLE☐ POST EMULSIFIED

FAMILY BRAND

PENETRANT

PENETRANT REMOVER

DEVELOPER

DEVELOPER TYPE

☒ NON AQUEOUS☐ AQUEOUS☐ DRY

BLACK LIGHT S/N

☒ OUTPUT > 1000 μ W/cm²☐ AMBIENT < 2 fc

LIGHTING EQUIP.

☐ FLASHLIGHT☐ TROUBLELIGHT☐ OUTPUT > 100 fc @ SURFACE

OTHER

LIGHT METER S/N

CAL DUE DATE

TEST SURFACE

SURFACE CONDITION

☐ AS GROUND☐ AS WELDED☐ MACHINED☐ SHOT BLASTED☒ CLEAN BARE METAL

SURFACE TEMPERATURE

☐ < -4°C/20°F☐ -4°C/20°F TO 10°C/50°F☒ 10°C/50°F TO 52°C/125°F☐ > 52°C/125°F

RESULTS-

☐ METRIC ☐ IMPERIAL

1 CROSSHATCH W.O.I.D 80136 ✓
 2 W.O.I.D 80137 ✓
 3 W.O.I.D 80138 ✓
 4 W.O.I.D 80135 ✓
 5 CROSSHATCH W.O.I.D 79629 ✓
 6 W.O.I.D 79743 ✓

ITEM ID D412-664-203 AFT
 ITEM ID D412-664-203 AFT
 ITEM ID D412-664-203 AFT
 ITEM ID D412-664-203 AFT
 ITEM ID D206-667-107BL FELD Blue
 ITEM ID D206-667-107BL FELD Blue

NO SIGNIFICANT INDICATION WAS DETECTED AS PER
 APPLICABLE STANDARDS.

8/17/14

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the use of the information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE

TECHNICIAN (SIGNATURE):

NAME (PRINT):

Andrew Sheldon

PRINT

SIGNATURE

DTR #

E84975

REPORT

REVIEWED BY:

NAME

INITIALS

CGSB LEVEL

SNT LEVEL

CGSB LEVEL

SNT LEVEL

CGSB REG. No.

3049

CGSB REG. No.

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

PT Sept 2005

Location/Lot Activity

Thursday, March 29, 2012 12:36:44 PM

Page 1 of 3

Criteria : All Items All Locations Lot: 71502 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Account Value Change	D2896-1 / Support	Main Warehouse		FAUT01		20.0000		20.0000		
		LG			10/19/2011	-20.0000	71502	-20.0000		(\$6,397.93)
		Main Warehouse		FAUT01		20.0000		20.0000		
		LG			10/19/2011	20.0000	71502	20.0000		\$6,397.93
								0.0000		\$0.00
Inv Adjustment	D2896-1 / Support	Main Warehouse	Found	FAUT01		21.0000		0.0000		
		LG053			3/7/2012	1.0000	71502	1.0000		\$319.90
		Main Warehouse	Found	FAUT01		21.0000		0.0000		
		LG053			3/7/2012	1.0000	71502	1.0000		\$319.90
		Main Warehouse	B/N correction	GOLD01		21.0000		0.0000		
		LG053			3/23/2012	1.0000	71502	1.0000		\$319.90
Issue	D2896-1 / Support	Main Warehouse	B/N correction	GOLD01		21.0000		0.0000		
		LG053			3/27/2012	1.0000	71502	1.0000		\$319.90
								4.0000		\$1,279.59
		Main Warehouse	73691 ✓	QUIR01		20.0000		20.0000		
		LG			10/19/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	73690 ✓	QUIR01		19.0000		19.0000		
Issue	D2896-1 / Support	LG			10/19/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	75417 ✓	QUIR01		18.0000		18.0000		
		LG			11/9/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	75416 ✓	QUIR01		17.0000		17.0000		
		LG			11/9/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	74376 ✓	FAUT01		16.0000		16.0000		
Issue	D2896-1 / Support	LG			11/21/2011	-1.0000	71502	-1.0000		(\$319.90)

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D2896-1 / Support	Main Warehouse	✓ 74377 -203 ✓	FAUT01		15.0000		15.0000		
		LG			11/21/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 76351 -203	DESJ02		35.0000		14.0000		
		LG053			12/6/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 76350 -203	DESJ02		34.0000		13.0000		
		LG053			12/6/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 77108 -203	DESJ02		33.0000		12.0000		
		LG053			12/9/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 77273 -203	LAVO01		32.0000		11.0000		
		LG053			12/9/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 77109 -203	DESJ02		31.0000		10.0000		
		LG053			12/13/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 77433	QUIR01		30.0000		9.0000		
		LG053			12/19/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 77434 ✓	QUIR01		29.0000		8.0000		
		LG053			12/20/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 77748	FAUT01		28.0000		7.0000		
		LG053			1/6/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 77533	FAUT01		27.0000		6.0000		
		LG053			1/6/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 77534	FAUT01		26.0000		5.0000		
		LG053			1/6/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 78576	FAUT01		25.0000		4.0000		
		LG053			2/22/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 78574	FAUT01		24.0000		3.0000		
		LG053			2/22/2012	-1.0000	71502	-1.0000		(\$319.90)

Iss
 71502
 11/10/13
 11/10/19
 74465

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D2896-1 / Support	Main Warehouse ✓	78575	FAUT01		23.0000		2.0000		
		LG053			2/22/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse ✓	78573	GOLD01		22.0000		1.0000		
		LG053			2/24/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse ✓	80135	FAUT01		22.0000		1.0000		
		LG053			3/7/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse ✓	80134	FAUT01		22.0000		1.0000		
		LG053			3/7/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	80585	GOLD01		22.0000		1.0000		
		LG053			3/23/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	80584	GOLD01		22.0000		1.0000		
		LG053			3/27/2012	-1.0000	71502	-1.0000		(\$319.90)
									-24.0000	(\$7,677.51)
Loc Transfer	D2896-1 / Support	Main Warehouse		GOLD01		0.0000		0.0000		
		LG053			11/30/2011	14.0000	71502	14.0000		\$4,478.55
		Main Warehouse		GOLD01		14.0000		14.0000		
		LG			11/30/2011	-14.0000	71502	-14.0000		(\$4,478.55)
									0.0000	\$0.00
WIP Receipt	D2896-1 / Support	Main Warehouse	71502	GOLD01		0.0000		0.0000		
		LG			10/3/2011	20.0000	71502	20.0000		\$6,397.93